

Work Order ID 62772

October 7, 2010 3:41:58 PM



Page 1

Item ID: D3191-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Backer Plate

Start Date: 10/07/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/10/09 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3191	B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3191

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

6061-063

B10-10-7

(3)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-10-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

510101/2

(x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 10/14/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

BL 10-10-12

(3)



HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

BL 10-10-14

(3)



Powdercoat

M112588

Memo

0.00

Powder Coating

START TIME: 11:30
OVEN TEMPERATURE: 320°
FINISH TIME: 12:00

160

QC3- Inspect Part Finish

0.00

=> BL 10/10/14

3 0



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3191-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Backer Plate

Start Date: 10/07/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 170

0.00



Packaging

Memo

0.00

Packaging

10/10/18 SP

32

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18

MF
10-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 8, 2010 8:04:35 AM

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Work Order ID: 62772



Parent Item: D3191-5



Parent Item Name: Backer Plate



Start Date: 10/07/10

Required Date: 10/14/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.23 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	80.7840	0.10999	0.115779			
6061-T6 .063 Sheet													

1310-10-7

Location

Loc Qty

Loc Code

MAT21

80.784

113608

80.784

113608

③

DART AEROSPACE LTD		Work Order:	62772
Description: Backer Plate		Part Number:	D3191-5
Inspection Dwg: D3191 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.219	+0.005/-0.001	.220	*		✓ RB12	
0.375	+/-0.010	.374	*		✓	
1.313	+/-0.010	1.313	*		✓	
2.250	+/-0.010	2.251	*		✓	
3.188	+/-0.010	3.187	*		✓	
3.52	+/-0.030	3.518	*		✓	
0.375	+/-0.010	.375	*		✓	
1.200	+/-0.010	1.200	*		✓	
3.300	+/-0.010	3.306	*		✓	
4.125	+/-0.010	4.121	*		✓	
4.50	+/-0.030	4.506	*		✓	
0.063	+/-0.010	.061	*		✓	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 10-10-7	Date: 10/10/12	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue	KJ	

CZ1010108
W10.62772

RELEASED
07/07/15

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3191-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -1: 0.10 lbs
-3: 0.10 lbs
-5: 0.09 lbs

B	TRANSFERRED TO "B" SIZE DRAWING AND UPDATED TO CURRENT STANDARDS. ADDED -5. REASON: SEE NCR 08-110.		AJS	08.11.26
A	NEW ISSUE		CP	03.05.27
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3191	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		BACKER PLATE	NTS	
DATE	08.11.26		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

